

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012416**Date Inspected:** 20-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 7AE/7BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE7-004. The welder is identified as #037743 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2.

Segment 6CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6F-009. The welder is identified as #666261 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 7AW

This QA Inspector observed match drilling of bolt holes for bolted splice connection plates in the Deck Plate U-ribs and Side Plate WT-stiffener flange, counter weight side.

Segment 6BW/6CW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) at locations of removed fit up plates ground flush along the Side Plate CJP segment splice, cross beam side.

CB5

This QA Inspector observed drilling of bolt holes in the Cross Beam Bottom Panel.

Segment 6AW

This QA Inspector observed fit up and tack welding of the bottom Counter Weight Connection Plate between panel points 40 and 41.

Segment 6AW/6BW

This QA Inspector observed ABF personnel performing MT at locations of removed fit up plates ground flush along the Side Plate CJP segment splice, cross beam side.

Segment 7AW/7BW

This QA Inspector observed grinding of the Side Plate CJP segment splice root pass after arc gouging.

ZPMC Quality Control (QC) Inspector is identified as Shen Jian Ho. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Miller,Mark

QA Reviewer